

Date: Tuesday, 12/02/2008 2:28:55 PM  
User: Linda Lacelle

## Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 37387  
**Estimate Number** : 10258  
**P.O. Number** :  
**This Issue** : 12/02/2008 **S.O. No.** :  
**Prsht Rev.** : NC  
**First Issue** : / / **Type** : SMALL /MED FAB  
**Previous Run** : 36849  
**Written By** :  
**Checked & Approved By** :  
**Comment** : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5KJ/  
RF

**Drawing Name** : LID PRO ARM ASSEMBLY (SHORT)  
**Part Number** : D2332041  
**Drawing Number** : D2332  
**Project Number** : N/A  
**Drawing Revision** : C  
**Material** :  
**Due Date** : 19/02/2008  
**Qty** : 12 **Um** : Each

### Additional Product

Job Number:



*Scrap*

**Seq. #:** **Machine Or Operation:** **Description :**

1.0 M304TR1000W049 304 RD Tube 1.0" x .049W



**Comment:** Qty.: 0.4331 f(s)/Unit Total : 5.1975 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch

~~M106015~~

~~AF~~

M105260

SB 08/03/07 (12)

2.0 M304R250 1/4" 304 SS Roundbar



**Comment:** Qty.: 0.1092 f(s)/Unit Total : 1.3104 f(s)

Material: Ø0.250" 304SS Rod

Batch M105950

SB 08/03/07 (12)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

CB 08/03/06 (12)

4.0 M304TR0500W035 304 RD Tube .500 x .035W



**Comment:** Qty.: 1.2502 f(s)/Unit Total : 15.0024 f(s)

304 RD Tube .500 x .035W

M106015 (14)

M106593 (16)

M107098 (1)

M104880 (1) + 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012  
(Note: Make (2) D2332-11 Prop Arms per assembly.)

SB 08/02/12 (2) (12)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

EB 08/03/06 (12)

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

(12x)

A/R SS Rod Batch:

M106593

M107051

08-04-24

SP-1

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PHOTO

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

Scrap

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch




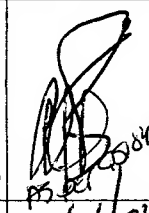

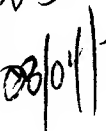
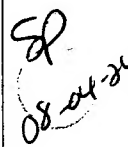

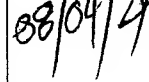
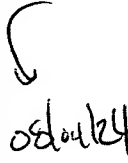
1 AN4-4A

Bolt

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: N/A Fault Category: Prod / Engr. Large NCR: (Yes) No DQA: 17 Date: 08/04/29  
 QA: N/C Closed: D Date: 08/04/29

NCR: <u>37387</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/24	#	During welding inspection it was found that there is a foreign object inside the Pop Arm.		ADD step to ensure there is no foreign object prior to welding	 08/04/24		 08/04/24	 08/04/24
		PC welder did not check for a foreign object prior to welding	 08/04/24	Scrap and destroy 12x all 12 parts.	 08-04-24	 08/04/24	 08/04/24	 08/04/24

NOTE: Date & initial all entries

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Job Number: 37387

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN960JD416L	Washer	

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut (or -4)	

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

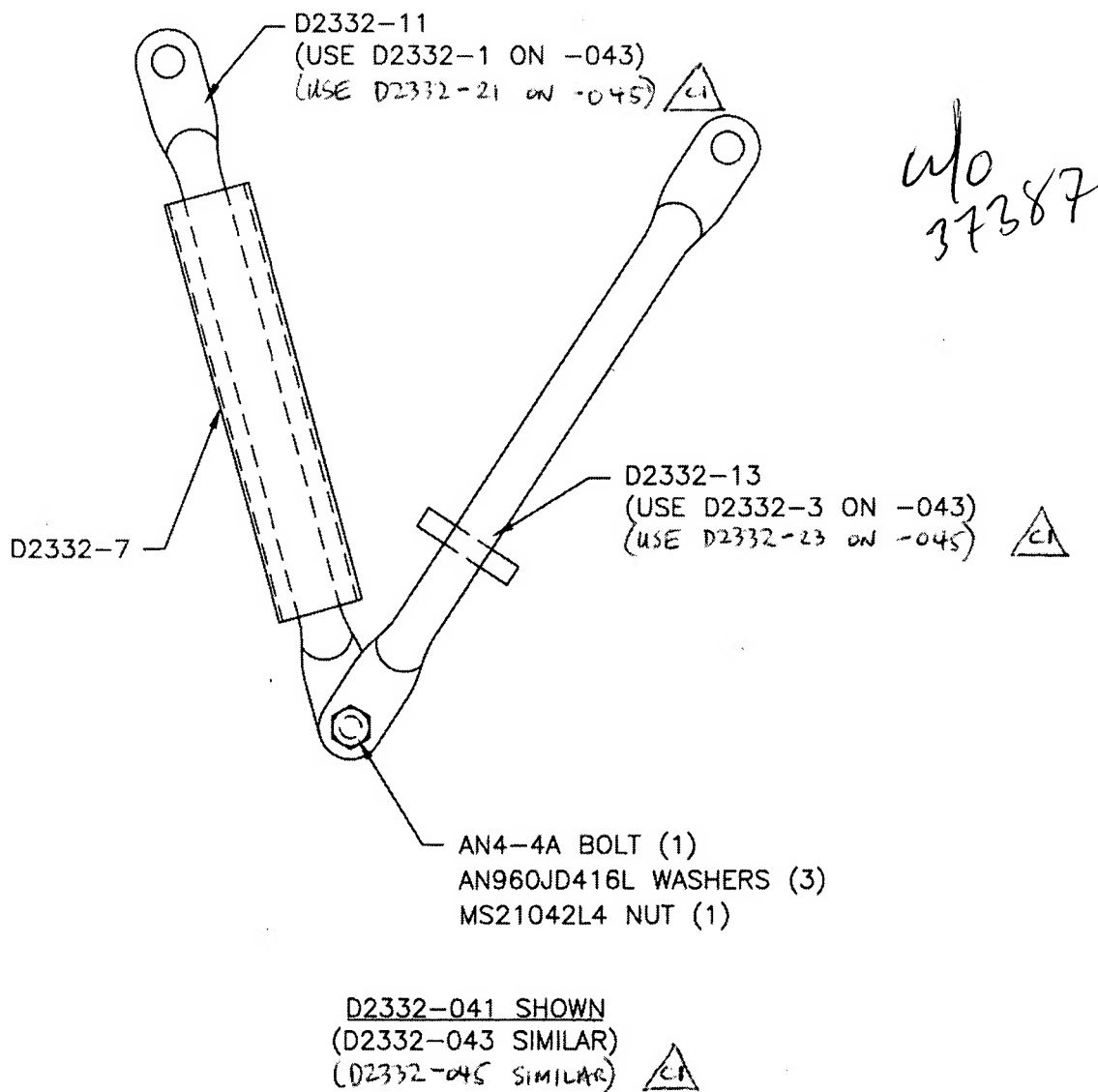
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03	TITLE LOD PROP ASSEMBLY		SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
CI	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED  
03.07.04



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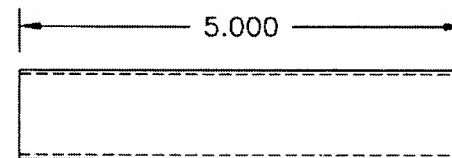
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**DART**

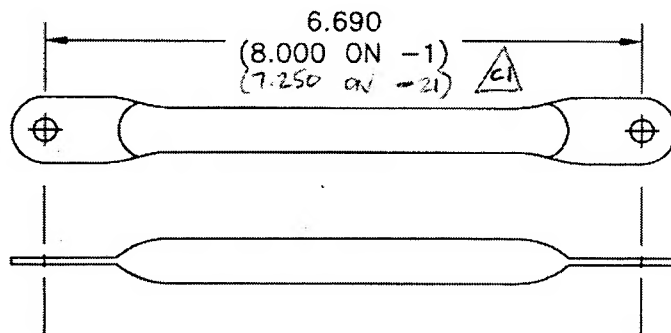


DESIGN	DRAWN BY	DART AEROSPACE LTD
#	#	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2332
DATE	TITLE	REV. C
03.07.03	LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2

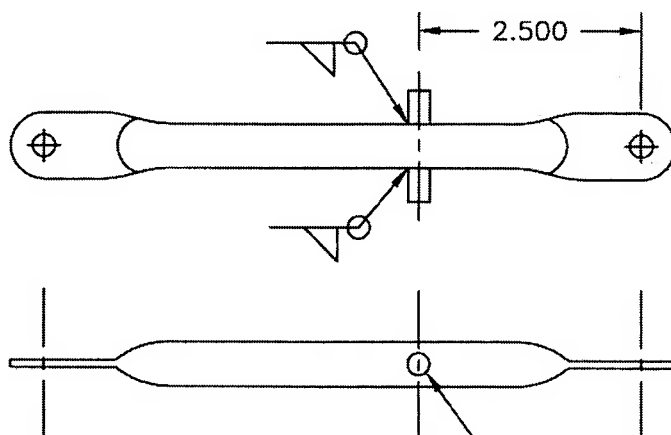
C	03.07.03	MAKE -041 Prop 6.69" LONG (END)
C1	03.08.06	MAKE -043 Prop 8.00" LONG (END)
		ADD -045 Prop (7.25" LONG)



D2332-7 LOCKING COLLAR



D2332-11 PROP  
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13  
M/F D2332-11 & D2332-5

{D2332-3 SIMILAR - M/F D2332-1 & D2332-5}  
{D2332-23 SIMILAR - M/F D2332-21 & D2332-5}

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13